

Work Order ID 163396***163396***

Page 1

Tuesday, June 27, 2017 11:37:04 AM

Item ID: D4527-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 6/29/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 03 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4527	B
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110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: BPROG REV: B

DEBURR

1.77

(4)

α 17/07/03

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.04

(4)

α 17/07/03

Work Order ID 163396

Tuesday, June 27, 2017 11:37:05 AM

163396

Page 2

Item ID: D4527-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 6/29/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 32 9-89
130						4	0		
Mill Conv	Memo	1.49							
Conventional Milling Machine	1- Drill holes as per dwg								17-07-05
	2- C'sink hole as per dwg								
	3- Ream 1.000" hole as per dwg								
	USE DT10120								
140		0.00							DAS 32 9-89
140						4	0		
QC	Memo	0.04							
Quality Control	QC2- Inspect parts off machine FAI/FAIB								17-07-05
150		0.00							DAS 08 9-89
150						4	0		
QC	QC8- Inspect parts - second check	0.08							
Quality Control	Memo								

SEE Attached

b.e 17-07-06

P.T.O.

163396

Tuesday, June 27, 2017 11:37:05 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 6/29/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/7/2017 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

Memo

0.60

HandFinish

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

Memo

0.04

QC

Quality Control

180

Identify as per dwg & Stock Location: St 451

0.00

180

Memo

0.04

Packaging

Packaging

Tuesday, June 27, 2017 11:37:05 AM

Page 4

Due Qty Qty Number Stamp
 _____ 17/7/12 
 U 17.07.11

Picklist Print

Tuesday, June 27, 2017 11:37:03 AM

Page 1

Work Order ID: 163396

163396

Parent Item: D4527-3

D4527-3

Parent Item Name: Bracket

Start Date: 6/29/2017

Required Date: 7/7/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.29 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X08.00 0		Purchased	No			110	f	9.0940	0.75	3.157895			

M6061T6B0 750X08 000

**

06/17/07/03

6061-T6 BAR .750" X 8.00"

Location

Loc Qty

Loc Code

MAT003

9.094

m135779

9.094

2.8

DART AEROSPACE LTD		Work Order:	163396
Description: Bracket		Part Number:	D4527-3
Inspection Dwg: D4527	Rev: B	Page 1 of 1	

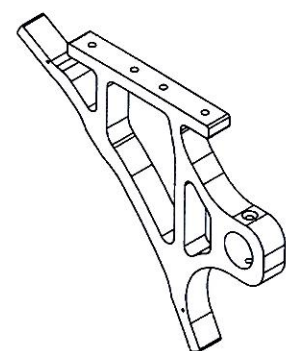
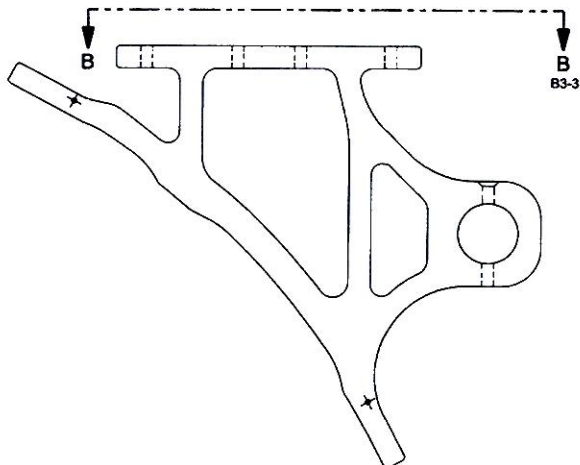
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.05	+/-0.030	1.05	✓		Vid-02	
3.85	+/-0.030	3.85	✓		Tap	
5.03	+/-0.030	5.026	✓			
5.16	+/-0.030	5.16	✓			
7.03	+/-0.030	7.024	✓			
1.79	+/-0.030	1.79	✓			
0.38	+/-0.030	.376	✓			
1.97	+/-0.030	1.965	✓			
2.250	+/-0.010	2.251	✓			
4.00	+/-0.030	4.00	✓			
4.20	+/-0.030	4.20	✓			
7.03	+/-0.030	7.03	✓			
0.38	+/-0.030	.385	✓			
4.82	+/-0.030	4.82	✓			
0.75	+/-0.030	.753	✓			
Ø0.080	+0.004/-0.001	0.080	✓		Caliper	JCL-08
1.13	+/-0.030	1.132	✓			
0.13	+/-0.030	0.130	✓			
1.13	+/-0.030	1.135	✓			
0.13	+/-0.030	0.131	✓			
Ø1.000	+0.003/-0.000	1.002	✓			
3.125	+/-0.010	3.129	✓			
0.875	+/-0.010	0.880	✓			
Ø0.196	+0.005/-0.001	0.196	✓			
CSK Ø0.377 x 100°	+/-0.010 x +/-0.5°	0.375	✓			
0.875	+/-0.010	0.880	✓			
Ø0.201	+0.005/-0.001	0.203	✓			
0.500	+/-0.010	0.500	✓			
1.500	+/-0.010	1.500	✓			
2.530	+/-0.010	2.530	✓			
1.500	+/-0.010	1.500	✓			

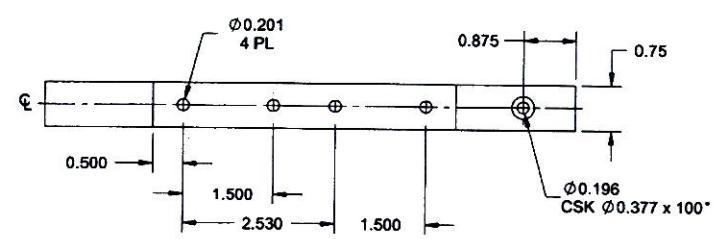
Measured by:	32 289	Checked by:	DAS 08	QC Inspector:	
Date:	17/07/03	Date:	17-07-06	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	15.02.26	Dimensions updated per Dwg Rev B	KJ	
C	15.04.24	Dimensions added	KJ	



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 163396 MJS
170703



SECTION VIEW B-B B5-3

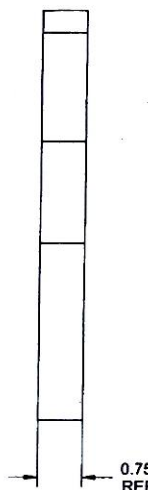
D4527-3 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 OR 6061-T6/T62 ALUMINUM SHEET
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.90 lbs

RELEASED
 2012-10-31

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR INDUSTRIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



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MFG. APPR.		D4527	SHEET 4 OF 4
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DQA:

Date: 2017-07-21



QA Closed:

Date: JUL 18 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>163 396</u> Part No. <u>D4527-3</u> NCR No. <u>17-6532</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; text-align: center;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																										
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Date: <u>17/7/5</u>	Step #: <u>130</u>	QTY Effective: <u>4</u>	MRB (QSI042) Approval DAS 12 9-89 <u>17/7/5</u> Completed By DAS 12 9-89 <u>J.C.L. 17/7/5</u> Lead hand / Supervisor Approval Verification <u>17/07/05</u> QC / QA Coordinator DAS 9 9-89 <u>17.07.05</u>																																																																																																																																											
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